Date:

Monday, 26/03/2007 12:39:23 PM

User:

Linda Lacelle

#### **Process Sheet**

Customer

Job Number **Estimate Number**  : CU-DAR001 Dart Helicopters Services

: 31459

P.O. Number

: 12567

This Issue Prsht Rev. : NIA : 26/03/2007

: NC

: 29384

: NIA

S.O. No. : HIM

Type

First Issue **Previous Run** 

Written By

Checked & Approved By

Comment

: Est. Rev:A

: LARGE FAB ASSY

**Drawing Name** 

: HELI-ACCESS STEP LH (FOLDING)

Part Number

· LIGHTZDSUUSS · UNDER REVIEW to meet sydens : D412630033

**Drawing Number** 

: N/A

**Project Number** : K **Drawing Revision** 

Material **Due Date**  : N/A : 02/04/2007

Qty:

1 Um: Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

DOCUMENT CONTROL

DC 1.0

Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG001

2.0 D2012107

Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

Clevis

Clevis Pick:

Qtv

Part Number D2012-107

Description

Clevis

Batch

B27520

3.0

D2803041

Bracket Assembly



Comment: Qty.:

1.0000 Each(s)/Unit Total:

Bracket Assembly LH

1.0000 Each(s)

**Bracket Assembly** 

Pick:

Part Number D2803-041

Description

4.0

D2804041

**Bracket Assembly** 



Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

**Bracket Assembly** 

Pick:

Qty Part Number D2804-041

Description

Bracket Assembly LH

B27102 - mF 07-04-02

Page 1

Form: rprocess

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,		

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Dowt No	_	DAD #	NOD V				

Part No:	_PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:	
			QA: N	1/C C	losed:	Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annessal	Annacial
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						;		

Date: Monday, 26/03/2007 12:39:24 PM Linda Lacelle User: **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 31459 Part Number: D412630033 Job Number: Seq. #: Description: **Machine Or Operation:** 5.0 D2807 Support Prop Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Support Prop Pick: Part Number Description Batch Qty B 28488 D2807 Gas Spring 2 6.0 D2813 Washer Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Washer Pick: Qty Part Number Description Batch 2 D2813 Washer 7.0 D3562041 STEP ASSEMBLY, LH Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch B29411 1 D3562-041 Step Weldment LH 8.0 D33951 Bushing Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Bushing Pick:

Part Number Description Batch
D3395-1 Bushing B-28455

4 D3395-1 Bushing B 28455
9.0 AN3C21A BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

BOLT Pick:

Qty

Qty

Part Number Description Batch
AN3C21A Bolt YIM 101189

mf 07-04-02

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
67.03.31	8	Pick: ay 2 02808	s:pacer	batch: 628600	mr	07-63-					

Part No:	PAR #:	_ Fault Category:	NCR: Yes No	DQA:	Date:
		,	QA: N/C C	losed:	Date:

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Ammerical	Approval
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector

Date: User: Seq. #:

Monday, 26/03/2007 12:39:24 PM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 31459

Part Number: D412630033

Job Number:

Machine Or Operation:

Description:

10.0

AN8C16

Comment: Qty.:

2.0000 Each(s)/Unit

Total:

2.0000 Each(s)

**Bolt** 

Pick:

2

Qty Part Number AN8C16

Description

Bolt

Batch

m 100695

AN310C8 11.0



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Nut

Pick:

Qty

Part Number AN310C8

Description

Nut

Batch

m100433

MS24665302 12.0



Cotter Pin



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Cotter Pin

Pick:

Part Number Qty

Description

Batch

MS24665-302 2

Cotter Pin (or AN380C3-4)

m(694)

13.0

NAS1515H3

Washer





Comment: Qty.:

6.0000 Each(s)/Unit Total:

6.0000 Each(s)

Washer

Pick:

Part Number

Description

Qty 6

NAS1515H3

Washer

Batch

M100993

14.0

NAS1515H5L

WASHER



Comment: Qty.:

4.0000 Each(s)/Unit Total:

4.0000 Each(s)

WASHER

Pick:

Part Number

Description

Batch

NAS1515H5L

Washer

M100680

mF 07-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	DAD # Foult Cotogony NC	D. Voc	No DOA		Data	

Part No:	PAR #:	_ Fault Category:	NCR: Yes N	o <b>DQA</b> :	Date:
			QA: N/0	Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
					1			
						\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		

Date: User:

Monday, 26/03/2007 12:39:24 PM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 31459

Part Number: D412630033

Description:

Job Number:



Seq. #:

**Machine Or Operation:** 

Washer

15.0

NAS1515H8





Comment: Qty.:

4.0000 Each(s)/Unit Total:

4.0000 Each(s)

Washer

Pick:

Part Number NAS1515H8

Description

Batch

Washer

m101331.

16.0

MS210433



Comment: Qty.:

4.0000 Each(s)/Unit Total:

4.0000 Each(s)

Nut

Pick:

Qtv Part Number MS21043-3

Description

Nut

Batch

MIG 2545

17.0

MS24693C280

Screw



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Screw Pick:

Part Number

Description

Batch

2

MS24693-C280

Screw (or MS24694-C565)

m101390

mc 07-09-02

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: m101472.

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: m 17045

19.0 •

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHAI	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
1							
·							
	·						
Part No	·	PAR #: Fault Category:	NCR: Yes	No DO	Δ:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		,	WORK ORD	ER NON-CONFORMANC	E (NCR)			
		Description of NC	Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspecto
,						-		

Date: Monday, 26/03/2007 12:39:24 PM User: ▶ Linda Lacelle **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 31459 Part Number: D412630033 Job Number: Seq. #: Description: **Machine Or Operation:** PACKAGING 1 PACKAGING RESOURCE #1 20.0 Comment: PACKAGING RESOURCE #1 DROP TIRE DE CLEO Pick Packing Kit 21.0 D28061 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Bushing Pick: Packing Kit Part Number Description 2 D2806-1 Bushing D28063 22.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) **Bushing** Pick: Packing Kit Part Number Description 2 D2806-3 Bushing D28105 23.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Strut Pick: Packing Kit Qty Part Number Description Batch <u>B27/03</u>\_レ 1 D2810-5 Strut D33961 24.0

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Pick: Packing Kit

Part Number

D3396-1

Spacer

Description

Date: Monday, 26/03/2007 12:39:24 PM User: -Linda Lacelle **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 31459 Part Number: D412630033 Job Number: Seq. #: Description: **Machine Or Operation:** Bolt AN4C6A 25.0 Total: 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Bolt Pick: Packing Kit Batch Qty Part Number Description 1100651 AN4C6A Bolt 1 26.0 AN4C10A 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Bolt Pick: Packing Kit Qty Part Number Description Bolt AN4C10A AN4C15A Bolt 27.0 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Bolt Pick: Packing Kit Part Number Description M100447 1 2 AN4C15A Bolt AN44C7A 28.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Evebolt Pick: Packing Kit Qty Part Number Description Batch M19620 7 Eyebolt AN44-C7A 29.0 AN5C15A

2.0000 Each(s)

M100229 1

Comment: Qty.:

Bolt

Qty

Pick: Packing Kit

Part Number

AN5C15A

2.0000 Each(s)/Unit Total:

Description

Bolt

Monday, 26/03/2007 12:39:24 PM Date: Linda Lacelle User: **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 31459 Job Number: Seq. #: Description: **Machine Or Operation:** NAS1515H4 Washer 30.0 7.0000 Each(s)/Unit Total: 7.0000 Each(s) Comment: Qty.: Washer Pick: Packing Kit Qty Part Number Description 1101369 V NAS1515H4 Washer Washer 31.0 NAS1515H5 7.0000 Each(s)/Unit Total: 7.0000 Each(s) Comment: Qty.: Washer Pick: Packing Kit Qty Part Number Description Batch NAS1515H5 Washer MS210434 32.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description MS21043-4 Nut MS210435 33.0 3.0000 Each(s)/Unit Total: 3.0000 Each(s) Comment: Qty.: Nut Pick: Packing Kit Qty Part Number Description Batch 3 MS21043-5 Nut INSPECT 100% KITS FOR COMPLETENESS 34.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 35.0 **PACKAGING 1** Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630 Location: PPP Rev:

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No		PAR #· Fault Category:	NCR: Yes	No DO	Δ. Φ	Date C	2/04/05			

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE S		Description of NC	Corrective Action Section B			Verification	A	A		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		

Date:

Monday, 26/03/2007 12:39:24 PM

User: "

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 31459

Part Number: D412630033

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

36.0

QC21

FINAL INSPECTION/W/O RELEASE





07/64/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 070405

W/O:		WORK ORDER O	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·							
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

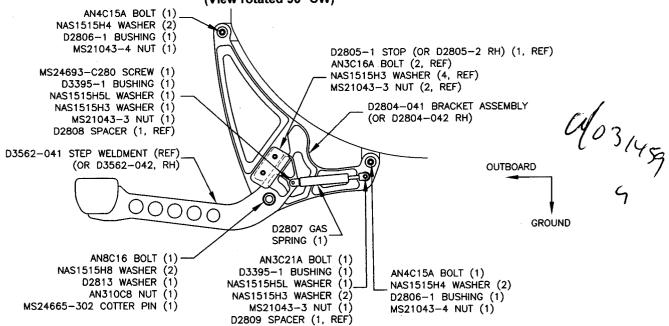
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	STEP	Description of NC	Corrective Action Section B			Verification	Annessal	Ammerial		
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
±* ·										

#### D412-630-033/-034 Heli-Access-Step<sup>™</sup> Installation

#### FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step<sup>™</sup> Installation (View rotated 90° CW) AN5C15A BOLT (1) NAS1515H5 WASHER (2) D2806-3 BUSHING (1) MS21043-5 NUT (1) MS24693-C280 SCREW (1) D3395-1 BUSHING (1) D2805-1 STOP (OR D2805-2 RH) (1, REF) NAS1515H5L WASHER (1) NAS1515H3 WASHER (1) MS21043-3 NUT (1) D2803-041 BRACKET ASSEMBLY D2808 SPACER (1, REF) (OR D2803-042 RH) AN8C16 BOLT (1) NAS1515H8 WASHER (2) D2813 WASHER (1) AN310C8 NUT (1) o MS24665-302 COTTER PIN (1) OUTBOARD 000000 D2807 GAS SPRING (1) AN3C21A BOLT (1) GROUND D3395-1 BUSHING (1) D3562-041 STEP WELDMENT (REF) AN5C15A BOLT (1) NAS1515H5L WASHER (1) NAS1515H5 WASHER (2) D2806-3 BUSHING (1) (OR D3562-042, RH) NAS1515H3 WASHER (2) MS21043-3 NUT (1)

#### FIGURE 15 – STA 155.06 for D412-630-033/-034 *Heli-Access-Step*<sup>™</sup> Installation (View rotated 90° CW)

D2809 SPACER (1, REF)



MS21043-5 NUT (1)

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Revision:

Κ

Date: 06.10.05